

Date: Wednesday, 26/09/2007 7:00:40 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WINDOW
Job Number :	31896		
Estimate Number :	10695		
P.O. Number :	N/A	Part Number :	D33001
This Issue :	26/09/2007	Drawing Number :	D3300 REV A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	A
Previous Run :	31896	Material :	N/A
Written By :	Due Date :		03/10/2007
Checked & Approved By :	Qty:		5 Um: Each
Comment :	Est A 04.11.30 New Issue KJ/RF Est B 07-09-25 now on water jet DD verified by EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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Comment: Qty.: 1.7430 sf(s)/Unit Total: 8.7150 sf(s)
 1/8" Polycast II Sheet
 Material: Polycast II Clear Acrylic sheet per MIL-P-5425, 0.125" thick
 (M-ACRYLIC-S.125)
 Batch: M104436 HB 07-10-3

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3300
 Dwg Rev: A HB 07-10-3
 Prog Rev: A
 2-Deburr if necessary



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-10-3

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Handwritten notes: 5 02/10/03 28 cast

Date: Wednesday, 26/09/2007 7:00:40 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 31896

Part Number: D33001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Identify, wrap in foam and Stock

SAD 07-10-11 (5) DL 07.10.05

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA-10-12 (5)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 57218

Co 7/10/12 (5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/10/12 (5)

Job Completion



U 07/10/12

Date: Tuesday, 4/17/2007 3:47:26 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WINDOW
Job Number	: 31896		
Estimate Number	: 10695		
P.O. Number	:	Part Number	: D33001
This Issue	: 4/17/2007 S.O. No. :	Drawing Number	: D3300 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 26396	Material	:
Written By	:	Due Date	: 5/20/2007 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	: Est: A 04.11.30 New Issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut window: 13.20" x 24.20"

2.0	MACRLICS125	1/8" Polycast II Sheet
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Comment: Qty.: 1.7430 sf(s)/Unit Total : 3.4860 sf(s)
 1/8" Polycast II Sheet
 Material: Polycast II Clear Acrylic sheet per MIL-P-5425, 0.125" thick
 (M-ACRYLIC-S.125)
 Batch: _____

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Trim as per template D3300-1T1
 Deburr, break all sharp edges 0.010 to 0.015
 Engrave part number and batch number as per Dwg D3300

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Identify, wrap in foam and Stock

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:47:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 31896

Part Number: D33001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

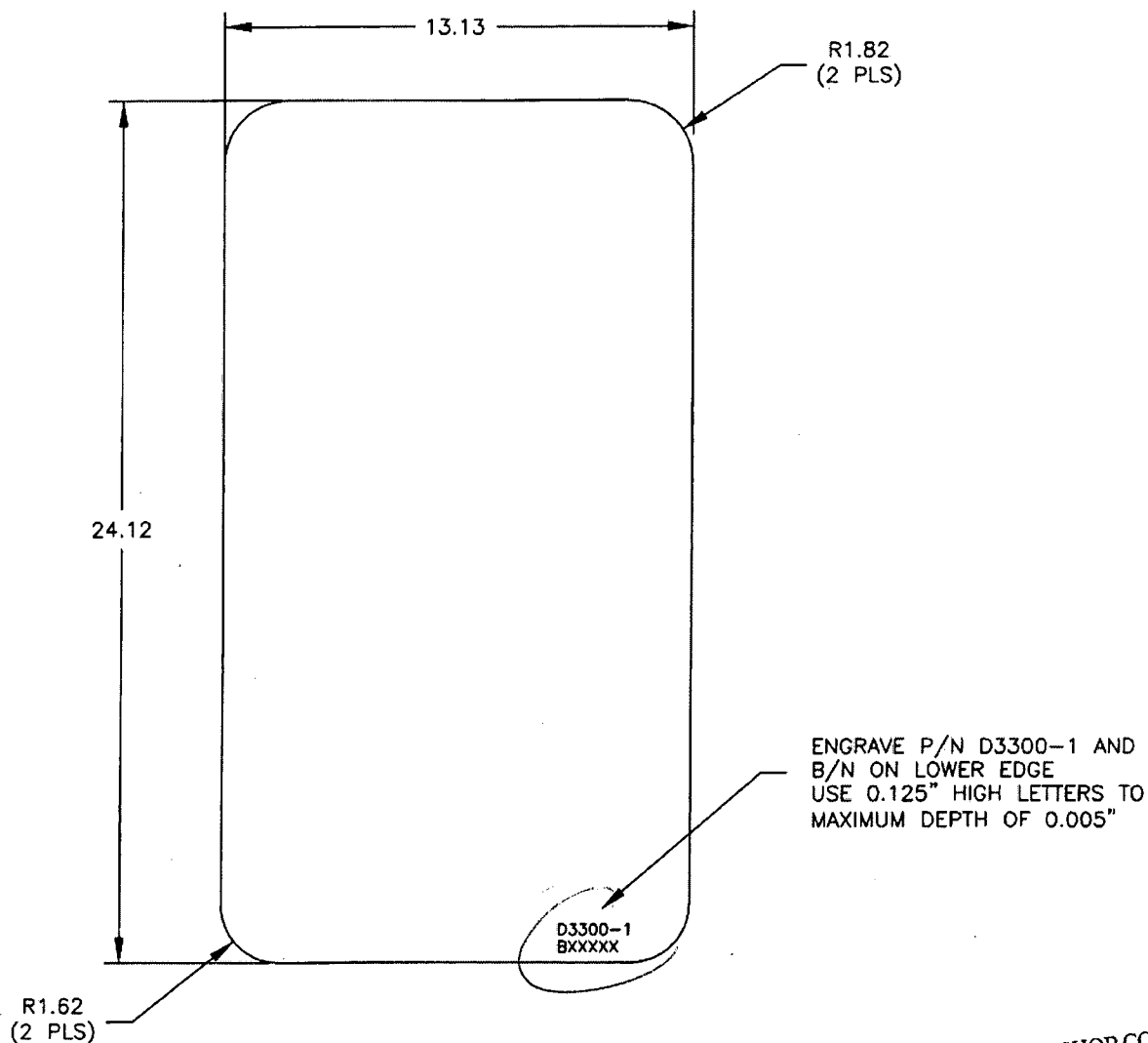
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3300	REV. A SHEET 1 OF 1
DATE 04.10.08		TITLE WINDOW	SCALE 1:5
A	04.10.08	NEW ISSUE	

RELEASED
04.11.23 H



D3300-1 WINDOW

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 0.125" THICK (REF DART SPEC. M-ACRYLIC-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TRIM USING D3300-1T1 TEMPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31896

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